

Work Order ID 56549

March 1, 2010 11:14:59 AM







Page 1

Item ID: D4064-041 Accept  Setup Start 
 Revision ID: Stop 
 Item Name: Lug ass'y

Start Date: 01/03/2010 Start Qty: 6.00  Cust Item ID:
 Required Date: 03/03/2010 Req'd Qty: 6.00  Customer:

Reference: *10-03-01*

Approvals: Process Plan Date: Tooling: Date: Run Start 
 QC: Date: SPC (Y/N): Date: Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
<i>D 4064</i>	<i>Rev A 10-03-01</i>								
100		0.00							
									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	Cut as per Dwg								
	DWG REV: <i>A</i>								
	PROG REV: <i>A</i>								
	DEBURR IF REQUIRED								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
									
QC	Memo	0.00							
Quality Control									

MAT NOT PULLED

B 10-3-1

(6)

10-3-1




6



6




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Item ID:	D4064-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Lug ass'y					
Start Date:	01/03/2010	Start Qty:	6.00	Cust Item ID:		
Required Date:	03/03/2010	Req'd Qty:	6.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Mill Conv	Memo	0.00							
Conventional Milling Machine	MILL RADS, DRILL HOLES AS PER DWG GRIND RAD .060"-.100" BY HAND	SL 10/03/02		5			1		
140  QC	QC2- Inspect parts off machine FAI/FAIB	0.00							
Quality Control	Memo	0.00					1		
150  QC	QC8- Inspect parts - second check	0.00							
Quality Control	Memo	0.00				5	①		

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Accept

Revision ID:

Item Name: Lug ass'y

Start Date: 01/03/2010 Start Qty: 6.00

Required Date: 03/03/2010 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

170

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control



10/03/02

x5

10/03/02

x5

BR 10-03-2

5

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Item ID: D4064-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Lug ass'y

Start Date: 01/03/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 03/03/2010 Req'd Qty: 6.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

0.00



HandFinish

Memo

0.00

Hand Finishing

ASSEMBLE GROMMETS AS PER DWG

9/5/10/03/02 (5)

200

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

5/6/10/02

(46)

210

0.00



Packaging

Identify as per dwg & Stock Location:

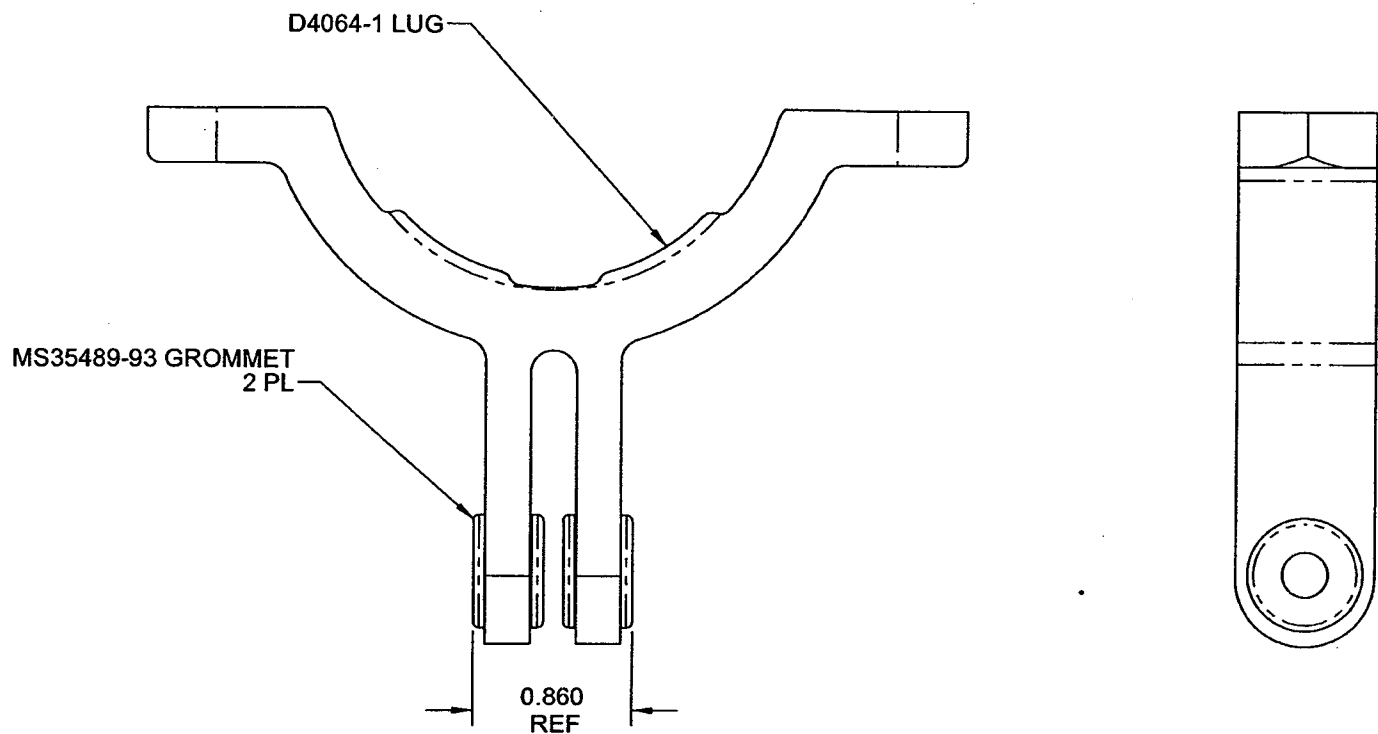
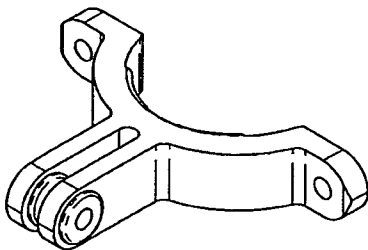
Memo

0.00

Packaging

Per 4/3/2 (5)

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4064-041	LUG ASSEMBLY
2	1	D4064-1	LUG
3	2	MS35489-93	GROMMET



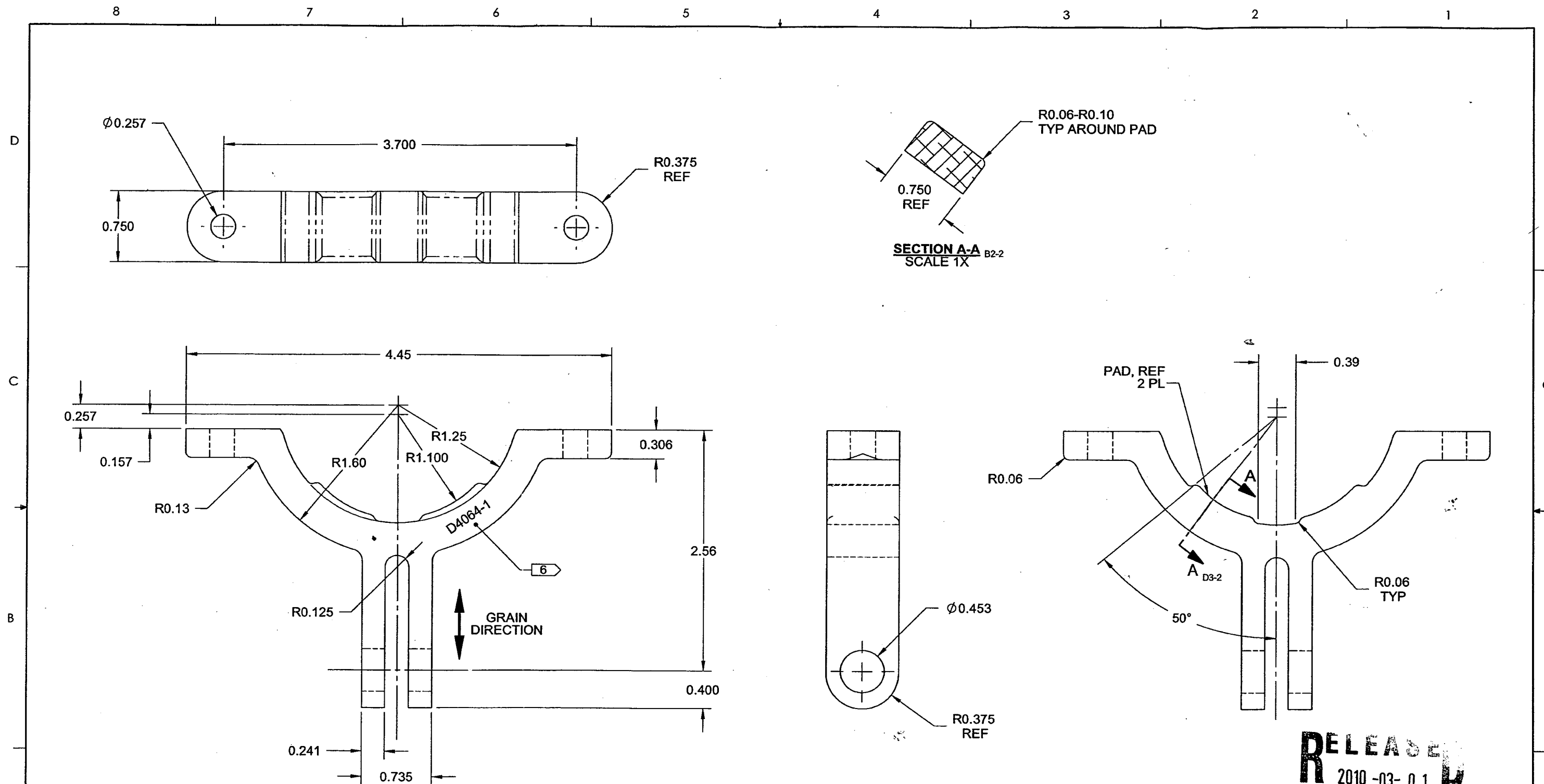
D4064-041 LUG

RELEASED
2010-03-01
WD

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.18 lbs

A	NEW ISSUE	CP	10.01.25
REV.	DESCRIPTION	BY	DATE
DESIGN	91	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	91		
CHECKED	91	DRAWING NO.	REV. A
MFG. APPR.	91	D4064	SHEET 1 OF 2
APPROVED	91	TITLE	SCALE
DE APPR.	91	CLAMP	NTS
DATE	10.01.25	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



D4064-1 LUG

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, BAR, OR EXTRUSION
PER QQ-A-200/8, QQ-A-225/8, QQ-A-250/8, ASTM B209, ASTM B211, OR ASTM B221
(REF DART SPEC. M6061T6B, M6061T6S)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO DEPTH OF 0.010 ± 0.005 IN THIS LOCATION,
WITH TOOL A TIP RADIUS OF 0.015 ± 0.005
- 7) WEIGHT: 0.18 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4064	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		CLAMP	NTS
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2010-03-01